

Date: Thursday, 17/07/2008 11:45:30 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 40580	
Estimate Number : 11969	
P.O. Number :	Part Number : D2065
This Issue : 17/07/2008 S.O. No. :	Drawing Number : D2065 UNDER REVIEW <i>RU</i>
Prsht Rev. : NC	Project Number : N/A <i>03.07.17</i>
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 34287	Material :
Written By :	Due Date : 06/08/2008 Qty: 10 Um: Each
Checked & Approved By : <i>JUL 08.7.17</i>	
Comment : Est: E 02.04.15 Added Dwg Rev.B1NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500V035	304 RD Tube .500 x .035W
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*W049**RU 03.07.17***Comment:** Qty.: 1.7063 f(s)/Unit Total: 17.0625 f(s)

304 RD Tube .500 x .035W

0.500 x 0.049

Seamless Tube (Ref. QSI 017 4.1.1.2) as per Dwg D2065 using DT8012.

Note: 1 end only

Batch: *M 108 324**PTO**86 08/07/23**(10)*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Punch 1/2" OD x .035" Wall 304/316 SS

Cut to length as per Dwg D2065

Form as per Dwg D2065 and template DT8251

Drill 0.188" Dia holes as per Dwg D2065 and template DT8251

Deburr

*W08-225**use for w/o 40748*

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.07.17	1	USE AISI 304/316 TUBING (0.500" x 0.049" WALL) DRAWING IN PROCESS OF APPROVAL PERMANENT CHANGE	PE	08.07.17	ALL	PE 08.07.17 QSI 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 40580

Part Number: D2065

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



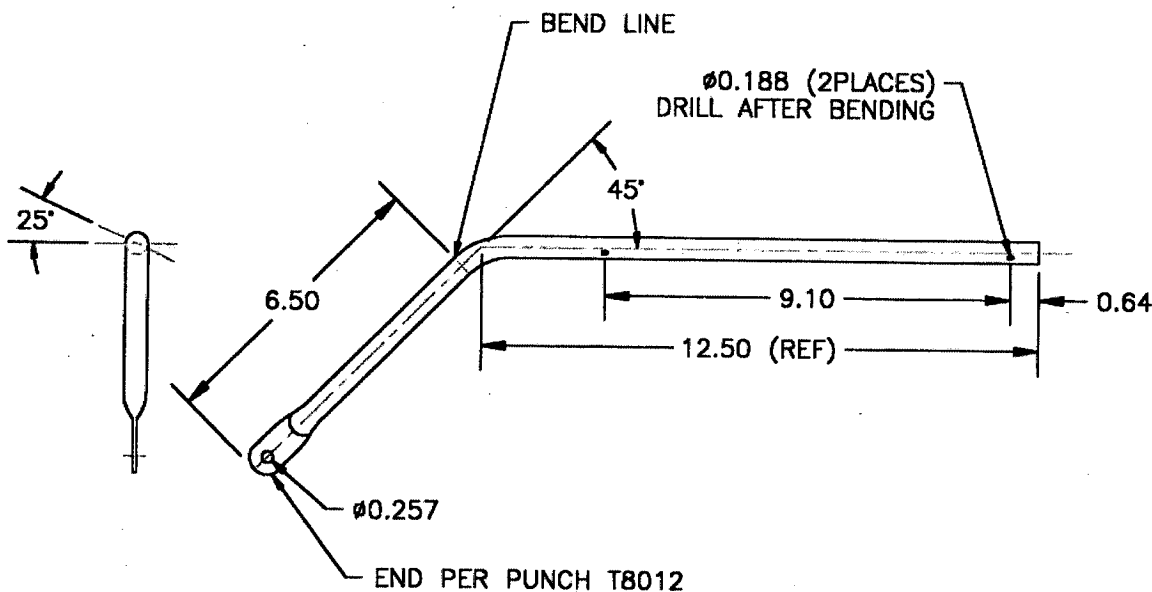
RELEASED
96/11/14 BxJ

UNDER REVIEW

03.05.14 *PT*
03.07.17

USE 0.049" WALL

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	B WILLIAMS		
CHECKED <i>CS</i>	APPROVED <i>CS</i>	DRAWING NO. D2065	SHEET 1 OF 1
DATE 92.03.12		TITLE ARM	SCALE 1:4
B	96.02.06	RE-DESIGN	
BI	02.03.25	ADD FINISH	



D2065 CUT LENGTH 19.5

0.049 *PT* 03.07.17

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL
FINISH: POWDER COAT BLACK SANDTEX (4,3,5,7) PER
DART QSI QSS 4.3 *BT*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40580

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries